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## SYNCHRONIZED PALLETIZER

### ABSTRACT OF THE DISCLOSURE

A synchronized palletizer includes a row conveyor and a layer head, each vertically  
5 reciprocating within a frame. An infeed conveyor delivers in series items row-by-row onto  
the row conveyor. The row conveyor moves to vertically coincide with the layer head and  
laterally transfer a row items onto the layer head. Once a complete item layer has been  
constructed on the layer head, the layer head collapses the layer together and drops the layer  
10 through its floor onto a pallet or stack of item layers therebelow. Generally, the layer head  
vertical position follows the top of stack of item layers and the row conveyor travels  
reciprocally between the infeed conveyor and the layer head to deliver items row-by-row to  
the layer head. A variety of alternative relative positioning schemes, however, may be  
implemented.